

# Work Order ID 84933

May-29-12 3:00:18 PM

**\*84933\***

Page 1

Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: \

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/29 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2906	Rev B								

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002

003 per EEN 12591 W

NA. 10

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

> CF 12-6-18

SAD 12.00.18  
7/6 12.1

NOTE: Date & Initials  
H:Forms/Quality Assurance/Approve

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Entries

**Work Order ID 84933**

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**\*84933\***

Page 2

Item ID: D209-669-043

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC3- Inspect Part Finish	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130		0.00							
<b>*130*</b>									
Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
	-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting								
	Pick:								
	Qty Part Number Description Batch								
	A/R Sikaflex-291 M121409								
	Sikaflex expire date: 13-4-12								
	Start Time: 15:45 Date: 12-6-18								
	Fin Time: 3:00 Date: 12-07-04								
	pick:								
	Qty	P/N	description	B/N					
	1	D2926-3	Web	384949					

D12-6-18

CFB 12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
<b>*140*</b>	BENDING MACHINE - CROSSTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150		0.00							
<b>*150*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.								
160		0.00							
<b>*160*</b>	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

7 DE / 12/06/19

BE 12/06/19

DE 12/07/09

B 12/07/09

1 0 BE 12/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Large Fab	0.00							
<b>*170*</b>									
Skidtubes									
Skidtubes	Memo	0.00							
	-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr								
	-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr								
	-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr								
190	QC5- Inspect part completeness to step on W/O	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

DP 12-7-4

8/17/07/05

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

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Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
<b>*200*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*210*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:15								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 11:45								
220	QC3- Inspect Part Finish	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									

1 0 12-8-5

IX 0 12/07/05

1 0 12/07/05

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*84933\***

Page 6

Item ID: D209-669-043

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 12/4/09Sikaflex expire date: 12/07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd &amp; Aft Cap as per Dwg D2906 and seal Fwd &amp; Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 12/4/09Sikaflex expire date: 12/07

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: 12/613( ~~8~~ ~~2~~ 12/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

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Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>									
QC	<b>Memo</b>	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
250		0.00							
<b>*250*</b>	Packaging								
Packaging	<b>Memo</b>	0.00							
Packaging	Identify and pack for shipping as per PPPD209-669-043								
	Location: _____								
	PPP Rev: <u>PPP 84909</u>								
260	QC21- Final Inspection - Work Order Release	0.00							
<b>*260*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

*12/27/12 (1)*

*12/27/18*

*MF 12-07-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

May-29-12 3:00:21 PM

Page 1

Work Order ID: 84933

\*84933\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD  
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 *D4202-1* Spacer		Manufactured	No				Each	81.0000		19			
									**	DC 12/07/04			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	5								
				77727	5								
				LG002	76								
				78806	6								
				79810	70								
D2500-1-190 *D2500-1-190* Ext'n -1' Beam Tube 4"		Manufactured	No			110	Each	91.0000	1	1			
									**	CF 12-6-18			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				HALL	91								
				74777	14								
				80061	77								
D2926-3 *D2926-3* Web		Manufactured	No			110	Each	0.0000	1	1			
									**	CF 12-6-18			
D2855 *D2855* Cap		Manufactured	No			230	Each	21.0000	2	2			
									**	2 12/07/08			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				FP002	21								
				65519	2								
				73347 ✓	16								
				75074	3								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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May-29-12 3:00:21 PM

Page 2

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\*84933\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A Purchased No

\*AN3-5A\*

Bolt

230 Each 1,090.000 4 4

\*\*

4

(28)

12/07/05



## Location

## Loc Qty

## Loc Code

ST350

1090

115371

46

117423

124

118626 ✓

31

119355

200

120187

500

121185

189

AN960JD10L ~~✗~~ NAS1149D0332J ✓ Purchased No

\*AN960JD10I \*

Washer

ALS7-1032-130

Purchased No

230 Each 0.0000 4 4

\*\*

44

(28)

12/07/05

121011



\*AI S7-1032-130\*

Insert

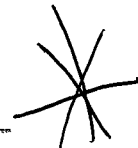
230 Each 2,136.000 44 44

\*\*

44

(28)

12/07/05



## Location

## Loc Qty

## Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

2085

119530

73

120181

12

121444

2000

121288 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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May-29-12 3:00:21 PM

Page 3

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\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

\*AN3C4A\*

BOLT

\*\*

44

28

12/07/05

## Location

## Loc Qty

## Loc Code

ST350

1458

120187

57

120521

28

120769

38

121203 ✓

1000

121556

335

AN960C10L

~~13~~

NAS1149C0332

Purchased

No

230

Each

0.0000

44

44

\*AN960C10I \*

122063

\*\*

44

28

12/07/05

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

\*D2594-3\*

O-Ring, 205 Skidtube

\*\*

14

28

12/07/05

## Location

## Loc Qty

## Loc Code

FP001

2418

65518

41

79496

984

79573

50

79755 ✓

1343

May-29-12 3:00:21 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230 Each

311.0000 14 14

**\*D2594-1\***

Plug, 205 Skidtube

\*\*

14

(2P)

12/07/05

Location

Loc Qty

Loc Code

FP001

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590 ✓

213

D3564-9

Manufactured No

230 Each

22.0000 1 1

**\*D3564-9\***

Wearshoe

\*\*

1

(2P)

12/07/05

Location

Loc Qty

Loc Code

FG

84870 ✓

4

76950

4

FP001

18

67590

4

69943

1

82255

13

D3564-11

Manufactured No

230 Each

8.0000 1 1

**\*D3564-11\***

Wearshoe

\*\*

1

(2P)

12/07/05

Location

Loc Qty

Loc Code

FG

84871 ✓

4

77056

4

FP001

4

80341

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-29-12 3:00:21 PM

Page 5

Work Order ID: 84933

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

\*84933\*

\*D209-669-043\*

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5      Manufactured      No      230      Each      13.0000      1      1      \*\*      1      (DP)      12/07/05  
Wearshoe

Location	Loc Qty	Loc Code
FG	2	
34806	2	
FP001	11	
77609	3	
82254 ✓	8	

D3566-1      Manufactured      No      230      Each      31.0000      2      2      \*\*      2      (DP)      12/07/05  
Gasket

Location	Loc Qty	Loc Code
FP	-22	
81619	10	
FP002	53	
68924	2	
80919	3	
83898 ✓	16	

D3566-5      Manufactured      No      230      Each      21.0000      1      1      \*\*      1      (DP)      12/05/05  
Gasket

Location	Loc Qty	Loc Code
FP	12	
82275 ✓	12	
FP002	9	
80374	3	
82274	6	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

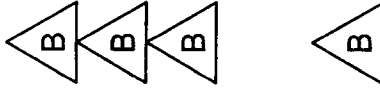
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QTY	QTY	Part Number	Description
-041	-043		
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 04933 MJS  
12/05/29

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291
- 4) ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.  
BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG CW D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.21		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2906	REV. B SHEET 1 OF 3
TITLE AH-1 (209) SKIDTUBE ASSEMBLY	SCALE NTS

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07.04.04

# Dart Aerospace Ltd

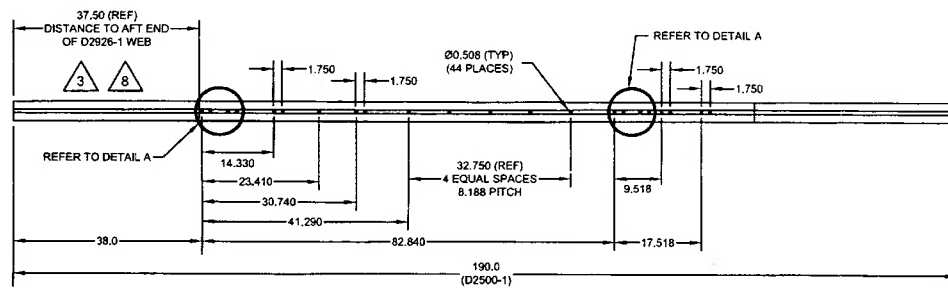
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

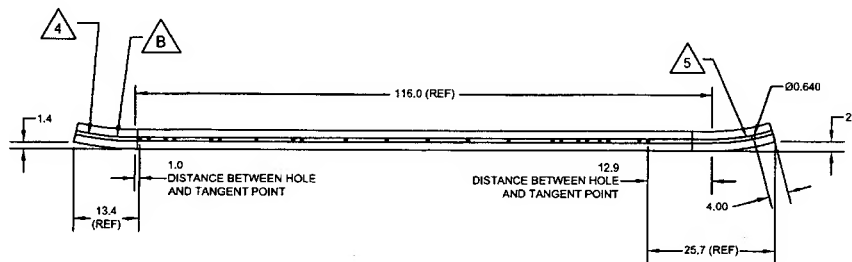
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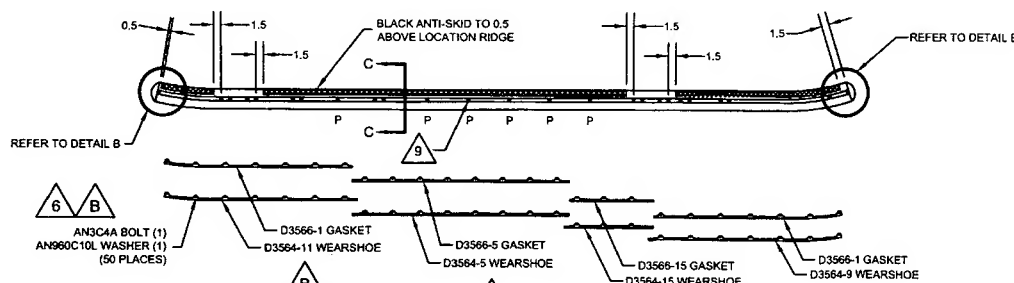
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**D2906-1 DRILLING DETAIL**

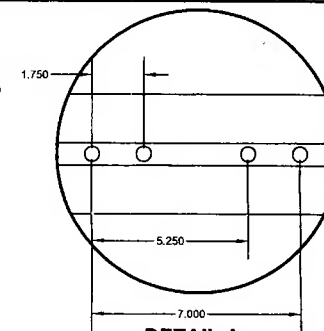


**D2906-041 BENDING AND CUTTING DETAIL**

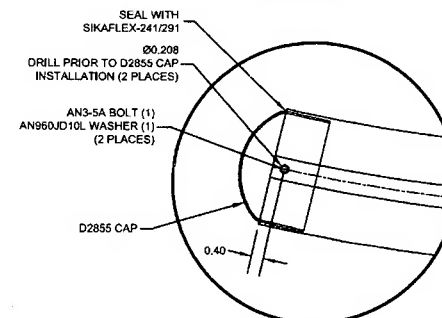


**D2906-041 ASSEMBLY DETAIL**

84933



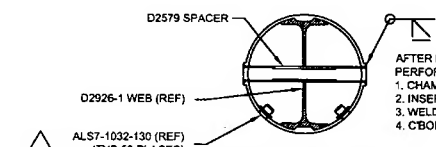
**DETAIL A**  
SCALE 1:4



**DETAIL B**  
SCALE 1:4

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**SECTION C-C**  
SCALE 1:4

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2579 SPACER (22 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C-BORE D2579 SPACER TO 0.437 X 1.00 DEEP

DESIGN	90	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.	91	D2906	SHEET 2 OF 3
APPROVED	92	TITLE	SCALE
DE APPR.	93	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
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